



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4148-1
Job Sheet 200199



Part No: D4148-1

Job Qty: 30 pcs

Part Name: Crosstube Lug Plate, Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.10.29 as per revC DD verf:EC
IPP REV:C 11.03.02 AS PER DWG REV.D DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	30 pcs	10/14/19	10/14/19	0.06	6.47	Waterjet - Flow	10/9/19	JRB
110	QC 2	30 pcs	10/14/19	10/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
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CANADA
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Container No: S221439

Part: D4148-1

Job No: 200199

Serial No/Batch: S221439

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/09/19

9/9/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8	30 pcs	10/14/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	6/9/19
				QC 8 - 12	JRB
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS NCT 0 9 2019 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Packaging 3-1 - Stock - B4B 30 pcs		10/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	Pc ST 080
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	

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					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	30 pcs	10/14/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	10.8210 sf (.3607 ea)	100-Waterjet - Flow - 1	5216338

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	11	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Crosstube Lug Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	0.131	
2	Fwd Crosstube Lug Plate	0.191Inches + 0.005 - 0.001	0.196 0.190	0.194	
3	Fwd Crosstube Lug Plate	0.380Inches + 0.006 - 0.001	0.386 0.379	0.379	
4	Fwd Crosstube Lug Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0.260	
5	Fwd Crosstube Lug Plate	0.500Inches + 0.008 - 0.001	0.508 0.499	0.499	
6	Fwd Crosstube Lug Plate	0.940Inches ± 0.030	0.970 0.910	0.941	
7	Fwd Crosstube Lug Plate	4.470Inches ± 0.030	4.500 4.440	4.490	
8	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	.756	
9	Fwd Crosstube Lug Plate	8.470Inches ± 0.030	8.500 8.440	8.472	
10	Fwd Crosstube Lug Plate	8.096Inches ± 0.010	8.106 8.086	8.095	
11	Fwd Crosstube Lug Plate	5.430Inches ± 0.030	5.460 5.400	5.438	
12	Fwd Crosstube Lug Plate	5.197Inches ± 0.010	5.207 5.187	5.196	
13	Fwd Crosstube Lug Plate	4.733Inches ± 0.010	4.743 4.723	4.738	
14	Fwd Crosstube Lug Plate	0.310Inches ± 0.010	0.320 0.300	0.315	
15	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	.751	
16	Fwd Crosstube Lug Plate	0.375Inches ± 0.010	0.385 0.365	0.375	
17	Fwd Crosstube Lug Plate	1.840Inches ± 0.030	1.870 1.810	1.842	
18	Fwd Crosstube Lug Plate	0.920Inches ± 0.030	0.950 0.890	0.922	

9/9/2019

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19	Fwd Crosstube Lug Plate	3.000Inches ± 0.010	3.010 2.990	3.004
20	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	.751
21	Fwd Crosstube Lug Plate	0.625Inches ± 0.010	0.635 0.615	.630
22	Fwd Crosstube Lug Plate	1.982Inches ± 0.010	1.992 1.972	1.986
23	Fwd Crosstube Lug Plate	0.991Inches ± 0.010	1.001 0.981	0.994
24	Fwd Crosstube Lug Plate	0.770Inches ± 0.030	0.800 0.740	0.772
25	Fwd Crosstube Lug Plate	1.540Inches ± 0.030	1.570 1.510	1.542
26	Fwd Crosstube Lug Plate	2.470Inches ± 0.030	2.500 2.440	2.469
27	Fwd Crosstube Lug Plate	0.820Inches ± 0.030	0.850 0.790	0.823
28	Fwd Crosstube Lug Plate	3.570Inches ± 0.030	3.600 3.540	3.578
29	Fwd Crosstube Lug Plate	1.230Inches ± 0.030	1.260 1.200	1.229
30	Fwd Crosstube Lug Plate	0.730Inches ± 0.030	0.760 0.700	0.745
31	Fwd Crosstube Lug Plate	0.125Inches ± 0.010	0.135 0.115	0.123
32	Fwd Crosstube Lug Plate	0.252Inches + 0.030 - 0.000	0.282 0.252	0.254

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION				DEPARTMENT/PROCESS				Date : _____ Sequence #: _____		QTY Affected : _____		MRB (QS1042)																																																																																			
Description Work Order Deviation		Disposition																																																																																															
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr><tr><td colspan="8">Other/Details:</td><td colspan="2"></td><td colspan="2"></td></tr></table>										Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Other/Details:												Completed By	
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